

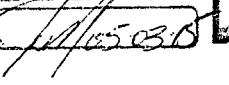
5/14

DART AEROSPACE LTD	Work Order:	22860
Description: Shaft Sleeve	Part Number:	D3233-7
Dwg: D3233 Rev. B	Qty:	20 4

Page 1 of 1

Step	Location	Procedure	Bx	Date	Qty
1	DC	Issue Traveler	(H)	05.03.31	20
2	CL	Turn as per Dwg D3233 Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020 SRA or AMS 5075 or AMS 5077 (M1020TR1.375W.125) Identify for D3233-7			
3	QC2	Inspect parts as they come off the machine Identify as D3233-7	Batch: M/7015	CPL 05.04.01	4
4	QC8	Second check	(R)	05.04.01	4
5	CM	Deburr	(J)	05.04.01	4
6	QC5	Inspect work to Step 5	(CPL)	05.04.01	4
7	ST	Identify and Stock	(R)	05.04.01	4
8	AC	Cost / part 22.80	(SAC)	05.04.01	4
9	DC	Close W/O 22.80 Inspect Level 21	(H)	05.04.05	4

Rev	Date	Change	Revised By	Approved
A	05.03.14	New issue	KJ/JLM	(JLM)

RELEASED


W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

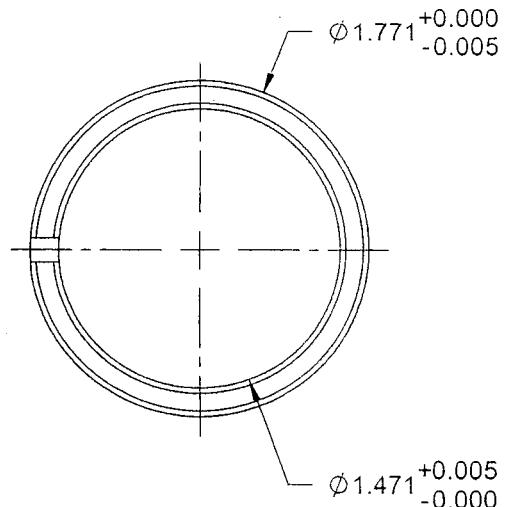
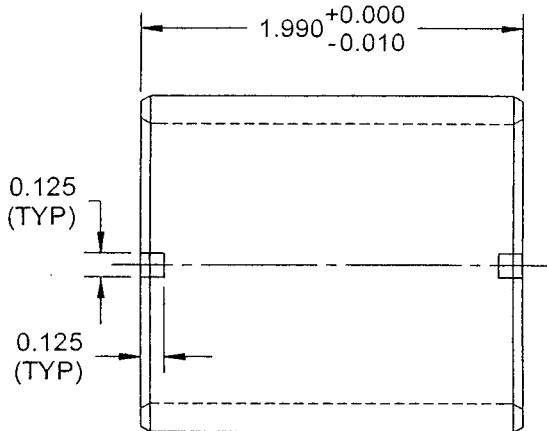
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

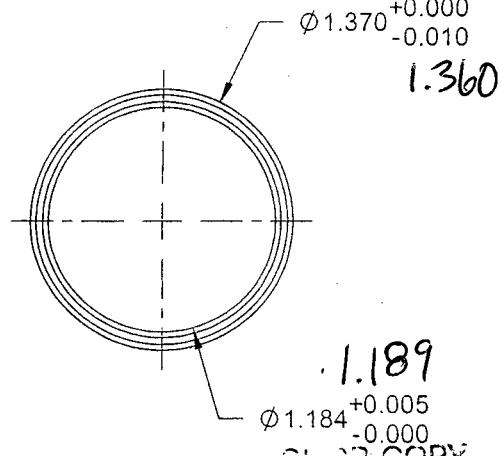
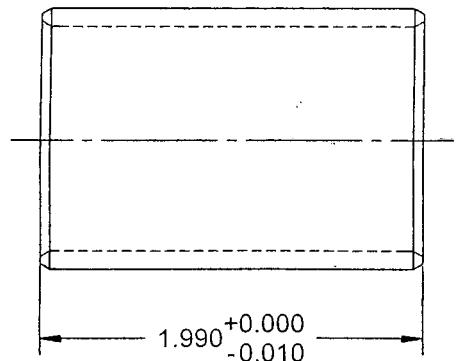
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE	05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513:00 OUT NOTICE MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

U T T T D COPY
S U T T A L E N D M E N T
WORK ORDER
NO. 22860

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~~1.134~~ 1.361

~~1.134~~ 0.255

~~1.185~~ 1.141

~~1.268~~ ~~1.334~~
1.344

Job Costing Report

Dart Aerospace Ltd.
HawkesburyMar 31, 2005
05:10 am

Work Order No : 0022860
 Project Name : D3233-7
 Project For : WK514
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3233-7
 Description : Shaft Sleeve
 Manufactured : Yes
 Amount Req'd : 204
 Amount Done : 0
 Start Date : 03-30-05
 Est Finish Date : 04-12-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00